

Date: Wednesday, 15/04/2009 9:47:07 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PROP ASSEMBLY		
Job Number	: 47186			Part Number	: D3085041		
Estimate Number	: 11558			Drawing Number	: D3085 REV A1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 15/04/2009	S.O. No.	:	Drawing Revision	: A1		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 27/04/2009		
Previous Run	: 45557			Qty:	4	Um:	Each
Written By	:			Comment	: Est. B02.03.05 Added dwg Rev.A1 NG		
Checked & Approved By	: <u>JUL 09.04.15</u>						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D30153	Locknut	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Lock Nut Pick: Qty Part Number Description Batch 1 D3015-3 Locknut <u>545394</u> 91513 <u>SL</u>			
2.0	D30811	Hinge	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Hinge Pick: Qty Part Number Description Batch 1 D3081-1 Prop Hinge <u>544081</u> <u>47294</u> <u>91513</u> <u>SL</u>			
3.0	D30821	Clip	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Clip Pick: Qty Part Number Description Batch 1 D3082-1 Clip <u>544082</u> <u>47294</u> <u>91513</u> <u>SL</u>			
4.0	D30841	Strut	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Strut Pick: Qty Part Number Description Batch 1 D3084-1 Prop arm <u>543164</u> <u>47295</u> <u>91513</u> <u>SP</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 47186

Part Number: D3085041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 AN45A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
1	AN4-5A	Bolt	M109061

9/5/13

SP

6.0 AN960JD10 Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
3	AN960JD10	Washer	M1771111279

9/5/13

SP

7.0 AN960JD10L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
3	AN960JD10L	Washer	M109632

9/5/13

SP

8.0 AN960JD416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	AN960JD416	Washer	M110363

9/5/13

SP

9.0 AN960JD516L Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
1	AN960JD516L	Washer	M14477

9/5/13

QJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3085041

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 MS21042L3 Nut

9/5/13



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
3	MS21042L3	Nut(or MS21042-3)	M110844

SD

11.0 MS21042L4 Nut

9/5/13



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut(or MS21042-4)	M110450

SD

12.0 MS27039113 Screw

9/5/13



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
3	MS27039-1-13	Screw	M105211

SD

13.0 SL69BS Ball Stud



SL

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Ball Stud

Pick:

Qty	Part Number	Description	Batch
1	SL69-BS	Ball Stud	M109239

9/5/13

SL

14.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Ep09/05/19 ④

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3085

15.0 QC5 INSPECT WORK TO CURRENT STEP



9/5/19 ⑩

Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 PACKAGING 1 PACKAGING RESOURCE #1



4X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 271

95120

50

17.0 QC21 FINAL INSPECTION/W/O RELEASE



09/05/20 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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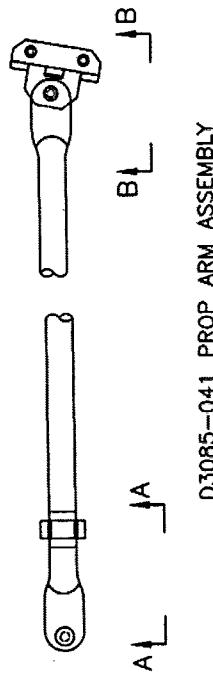
NOTE: Date & initial all entries

DART

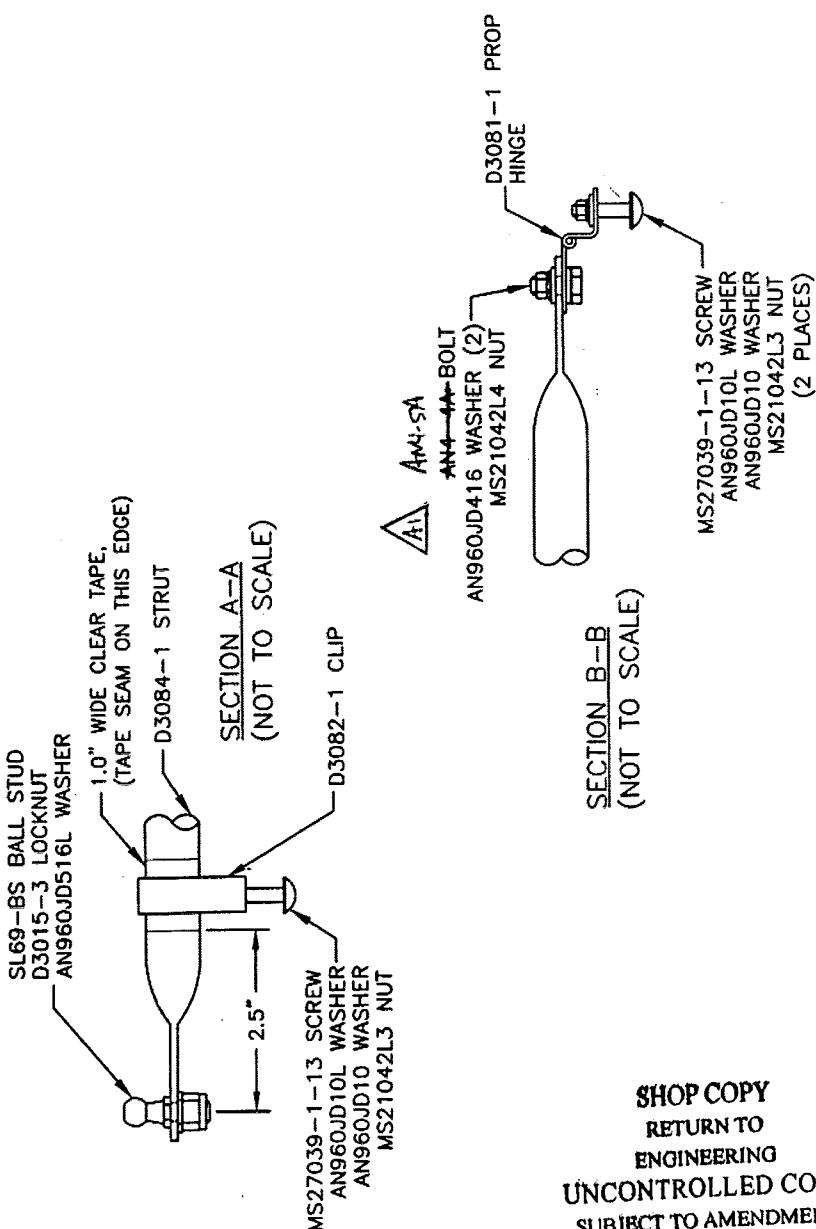
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10/10/02

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3085 REV. A SHEET 1 OF 1
DATE		TITLE PROP ARM ASSEMBLY SCALE 1:5
A	02.01.23	NEW ISSUE
A1	02.02.25	AN4-5A WAS AN4-4A

RELEASED
02-01-25 #



D3085-041 PROP ARM ASSEMBLY



MS27039-1-13 SCREW
AN960JD10L WASHER
AN960JD10 WASHER
MS21042L3 NUT
(2 PLACES)

SECTION B-B
(NOT TO SCALE)

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11186

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